

Date: Monday, 02/02/2009 4:03:11 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET BASE ASS'Y (A119)
Job Number : 45429B	
Estimate Number : 12431	
P.O. Number :	Part Number : D3516041
This Issue : 02/02/2009 S.O. No. :	Drawing Number : D3516 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 45428B	Material :
Written By :	Due Date : 01/04/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 09.02.03</u>	
Comment : EST rev. A 06.05.31 Preliminary EC	
EST rev. b 06.07.27 updated EC	
Est Rev:C 08-02-25 ECN 1138P DD verified by: LL	
Est Rev:D 08-03-18 ecn 1136 DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34421	Shim
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Shim
 Batch: B46767 → 2x

SM 09/04/07

2.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Mounting Bracket
 Batch: B45684 → 2x

SM 09/04/07

3.0	D351611	Clevis
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
 CLEVIS
 batch: B45714 → 6x

SM 09/04/07

4.0	D351613	Clevis
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 CLEVIS
 batch: B45561 → 4x

SM 09/04/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 45429B

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Spacer Bushing
Batch: *B44365 → 1x*
B39560 → 1x

SY 09/04/07

6.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Basket Hinge
Batch: *B46626 → 2x*

SY 09/04/07

7.0	D31661	Basket Hoop
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
RIB
Batch: *B46628 → 2x* *B46867 → 2x*

SY 09/04/07

8.0	D37251	Hoop
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
HOOP
batch: *B45575 → 2x*

SY 09/04/07

9.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 53.1825 f(s)/Unit Total: 53.1825 f(s)
AISI 304 SQ Tube .75x.75x.065W
Batch: *M110969 (13.1825)* *M111148 (40.00)*

SAD 09-03-25 *(1)*

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3516-1 as per dwg D3516

SAD 09-03-25 *(1)*

2-Cut rib D3516-3 as per dwg D3516

SAD 09-03-25 *(1)*

3-Cut rib D3516-5 as per dwg D3516

SAD 09-03-25 *(1)*

4-Cut rib D3516-7 as per dwg D3516

SAD 09-03-25 *(1)*

5- Cut rib D3516-15 as per dwg D3516

SAD 09-03-25 *(1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 45429B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Cut rib D3516-9 from D3166-1 (4) using DT8365 jig

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



PTO

Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3516

SM 09/04/09 (1)

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ID 09-04-09

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ID 09-04-09

✓ 14.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 60.0000 sf(s)/Unit Total : 60.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: M111173

SAD 09-04-08 (1)

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

SAD 09-04-08 (1)

2-Cut expanded metal for base ends as per dwg D3516

SAD 09-09-08 (1)

3-Weld expanded metal to base as per dwg D3516

16.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL 09-04-15

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/15 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3516-041 PAR #: N/A Fault Category: Prod/Ins. Lrg NCR: Yes No DQA: D Date: 09/04/09
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/04/09

NCR: <u>45429B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-04-09	1.0 + 3.0 RL	D3516-11 was put in wrong place Lack of attention.	<u>[Signature]</u> <u>09/04/09</u>	cut off D3516-11 and replace with new one Batch # <u>45714</u>	<u>[Signature]</u> <u>09/04/09</u>	PD 09-04-09	<u>[Signature]</u> <u>09/04/09</u>	<u>[Signature]</u> <u>09-04-09</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 45429B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

POWDER COATING

POWDER COATING



M 101939



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

pressure-wash 09-04-15 (U) 2d

1ST COAT:

START TIME:

8:00am

OVEN TEMPERATURE:

400°F

FINISH TIME:

8:30am

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

8:45am

OVEN TEMPERATURE:

400°F

FINISH TIME:

9:15am

JA 09-04-16 (U)

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 09/04/17 (P)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

45429

9/4/21

(N)

SN

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 JA

Job Completion



mf 09-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

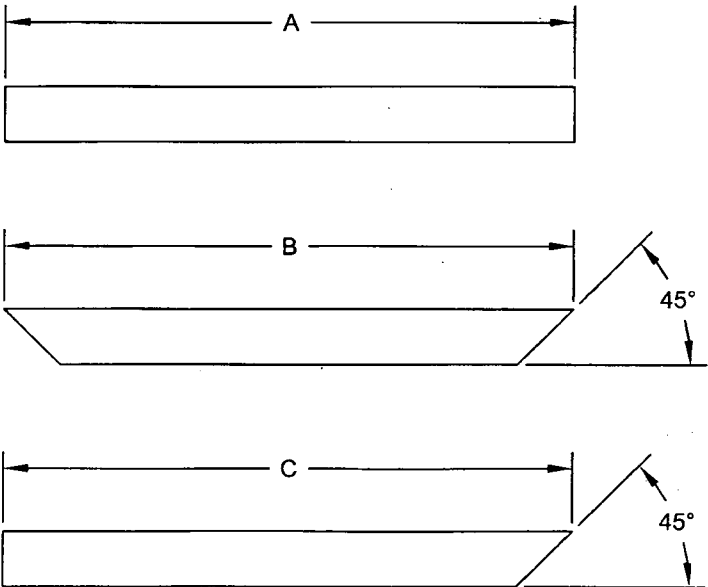
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	LENGTH C	DESCRIPTION
D2232-3	2	N/A	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	N/A	BUSHING
D2581	2	N/A	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	N/A	SHIM
D3516-1	2	—	102.00	—	RIB
D3516-3	2	—	—	2.70	RIB
D3516-5	8	26.75	—	—	RIB
D3516-7	3	45.50	—	—	RIB
D3516-9	4	N/A	N/A	N/A	RIB (MAKE FROM D2235-3)
D3516-11	6	N/A	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	N/A	CLEVIS
D3516-15	2	—	—	19.32	RIB
D3725-1	2	N/A	N/A	N/A	HOOP



D3516-041 BASKET BASE ASSEMBLY NOTES:

- 1) MATERIAL:
FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL
(REF. DART SPEC. M304TS0.750W.065)
MESH - 3/4-16F EXPANDED STAINLESS STEEL
(REF. DART SPEC. M304EX0.75-16F)
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 75 lbs
- 8) WELDING: PER DART QSI 004

C	ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST	MB	08.02.20
B	ADD QTY.(4) D3516-13; QTY.(6) D3516-11 WAS QTY.(1) SEE TR-D119-756-1 REV. A	MB	06.07.25
A	NEW ISSUE	MB	06.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY	NTS
DATE	08.02.20	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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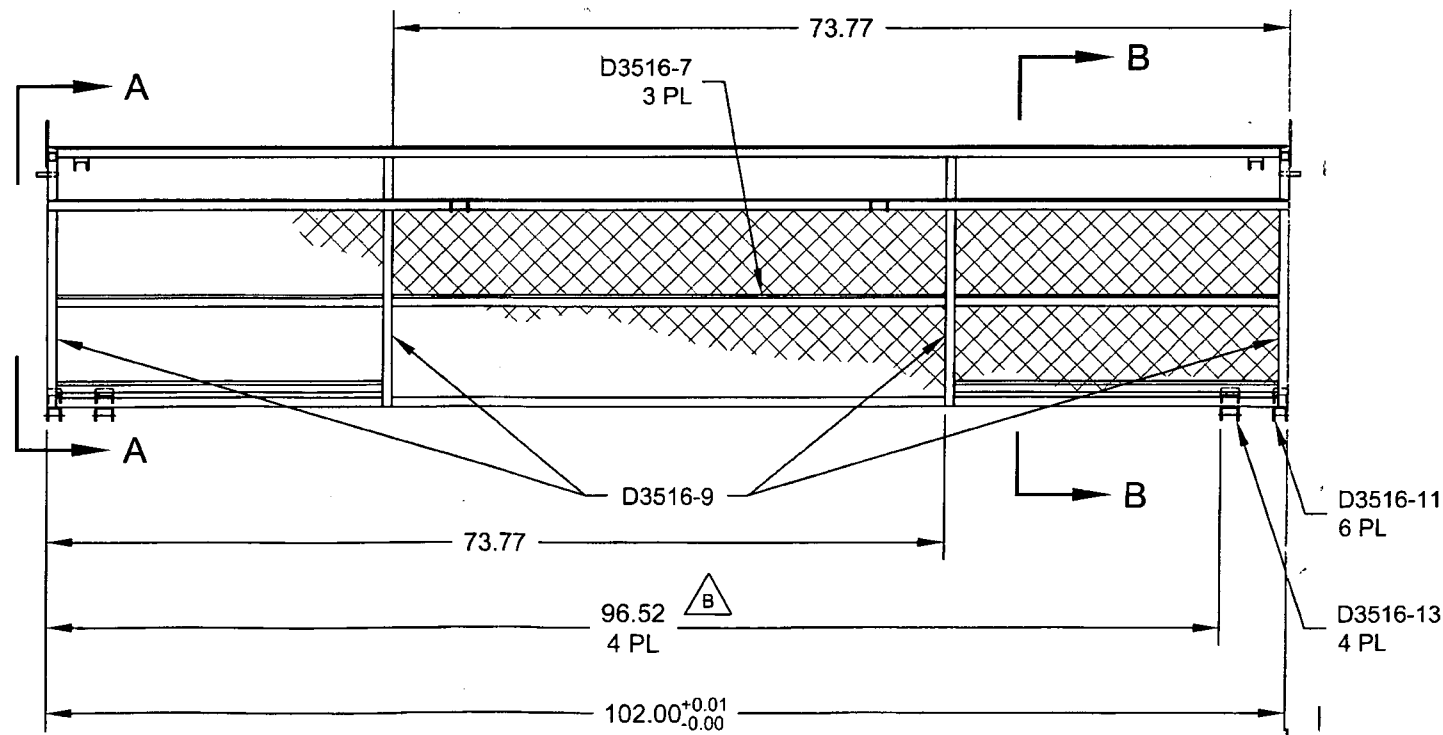
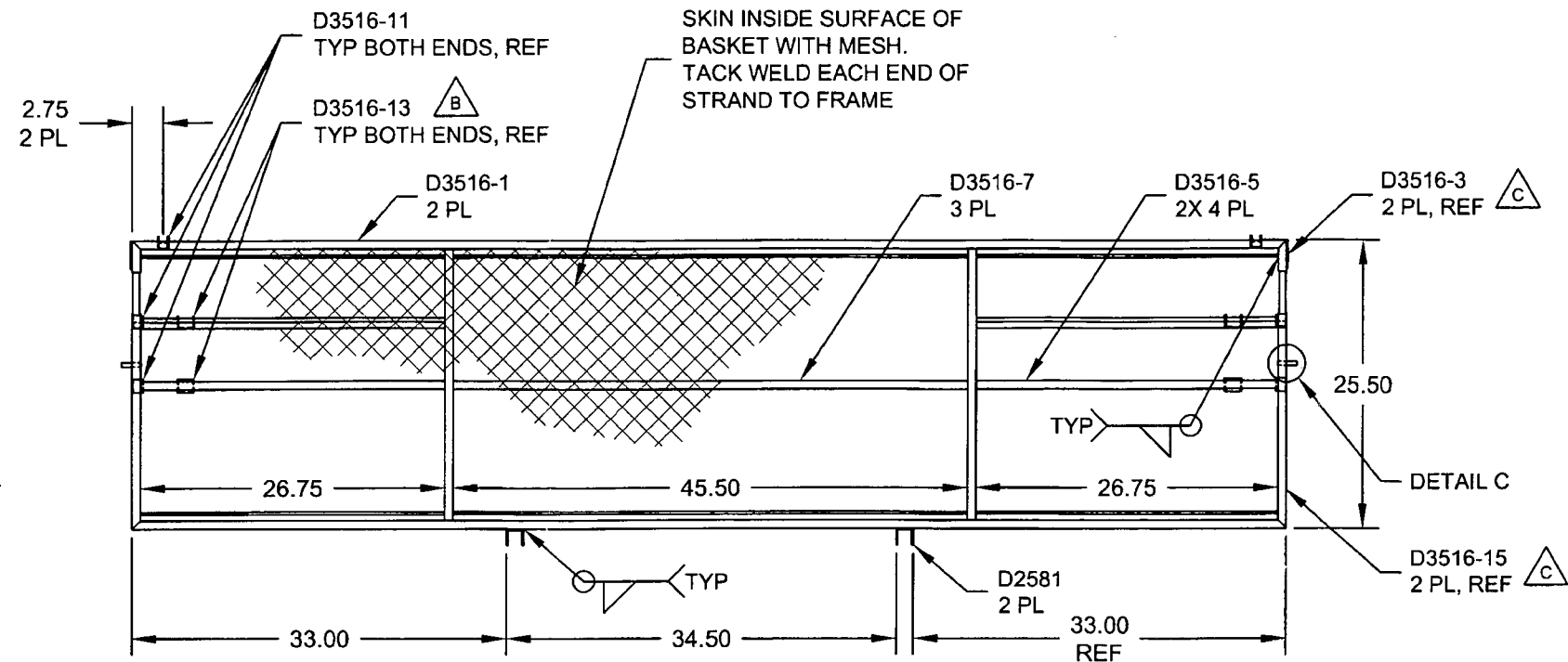
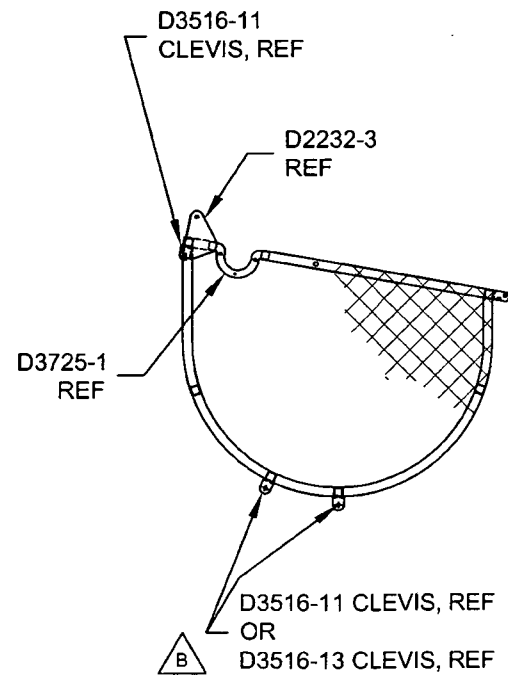
8 7 6 5 4 3 2 1

D

C

B

A



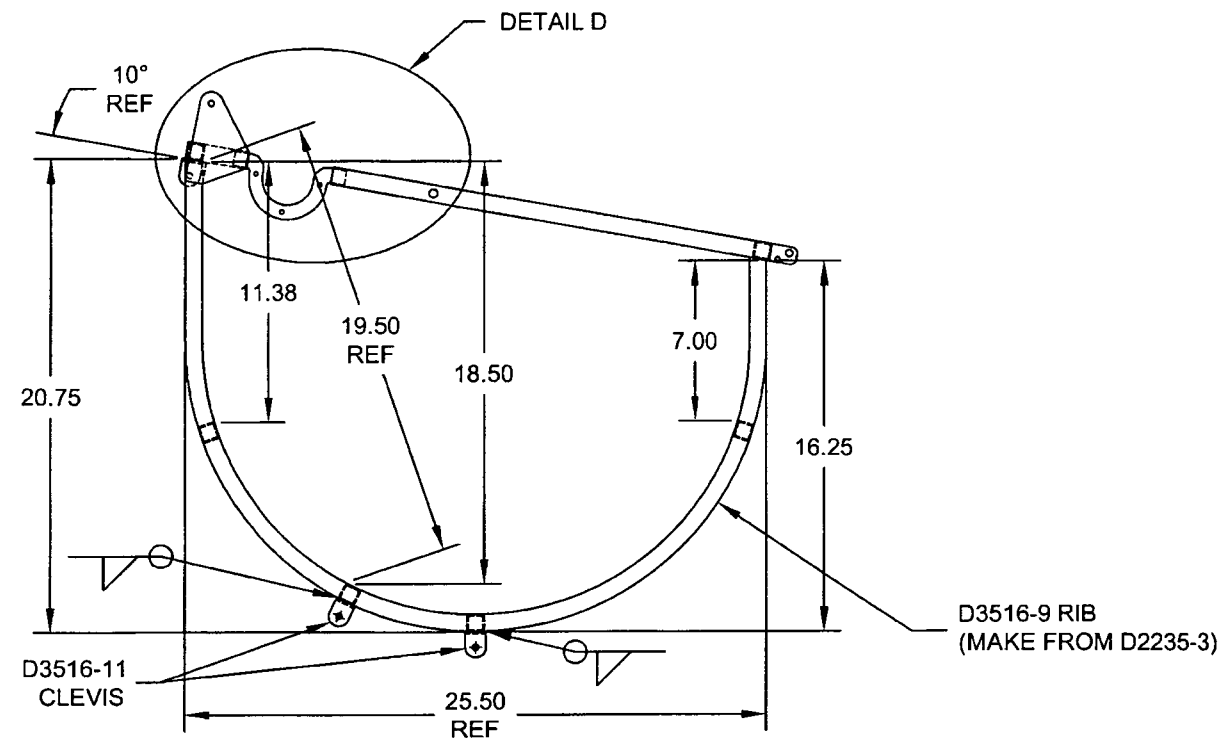
D3516-041 BASKET BASE ASSEMBLY

1108-03 n/m/p

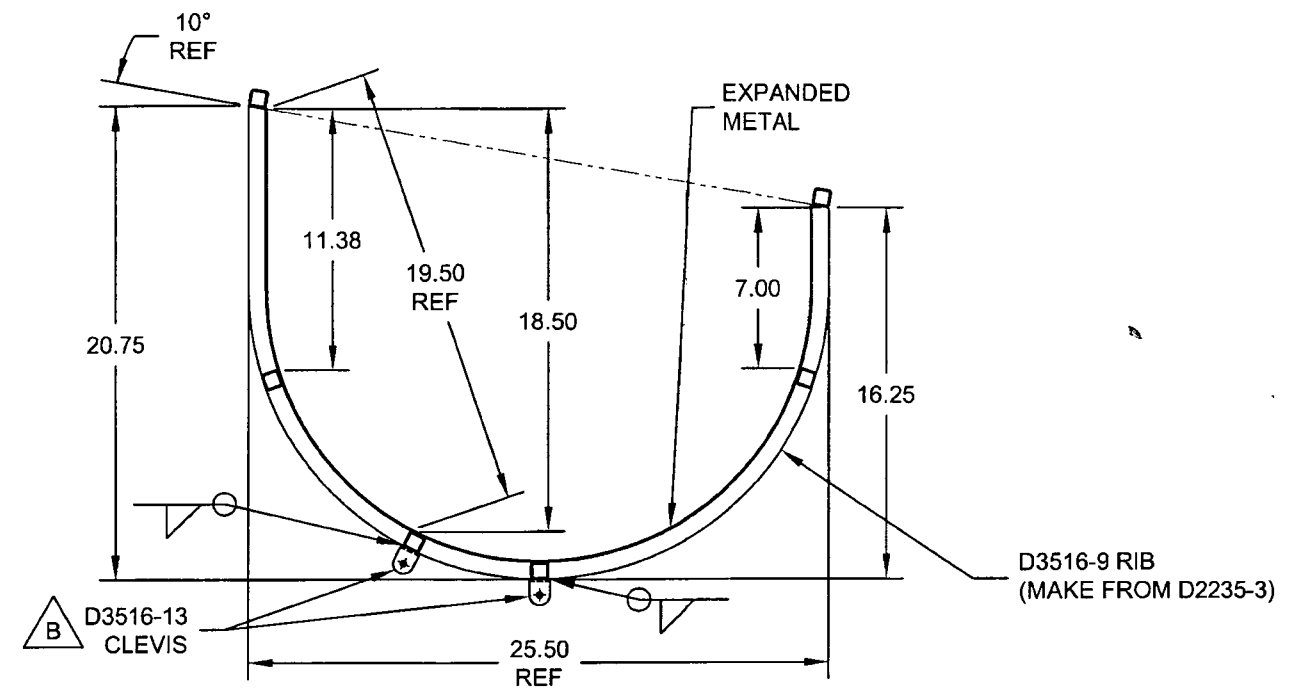
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MFG. APPR.		D3516	SHEET 2 OF 4
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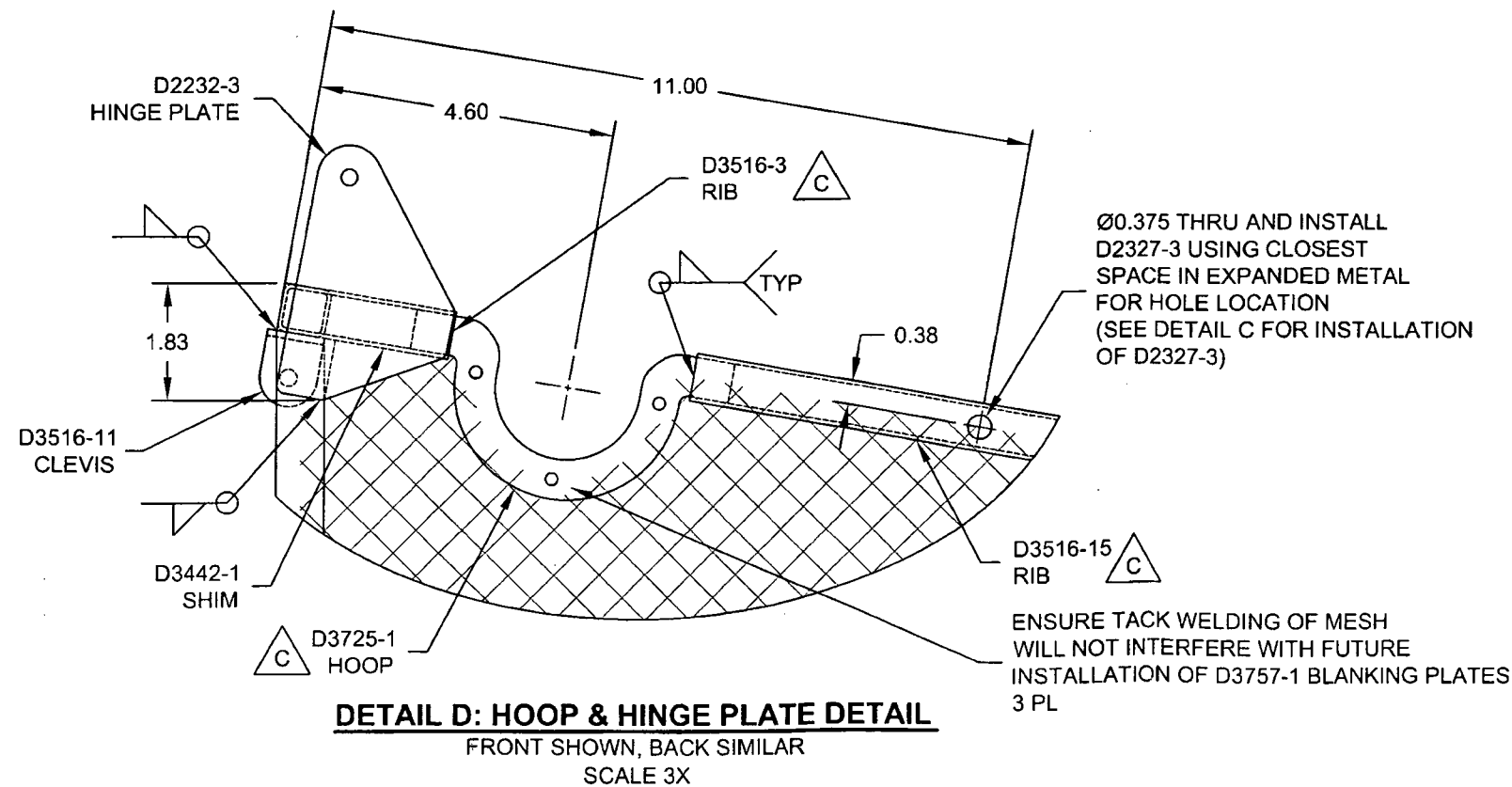
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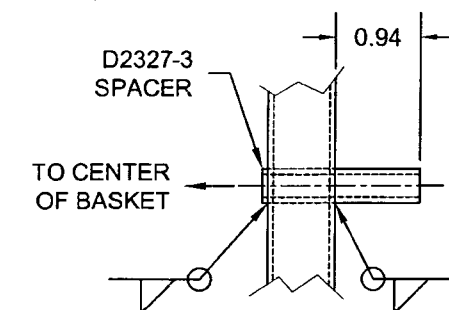
SECTION A-A: END RIB DETAIL
(MESH NOT SHOWN FOR CLARITY)
TYP BOTH ENDS



SECTION B-B: CENTER RIB DETAIL
2 PL



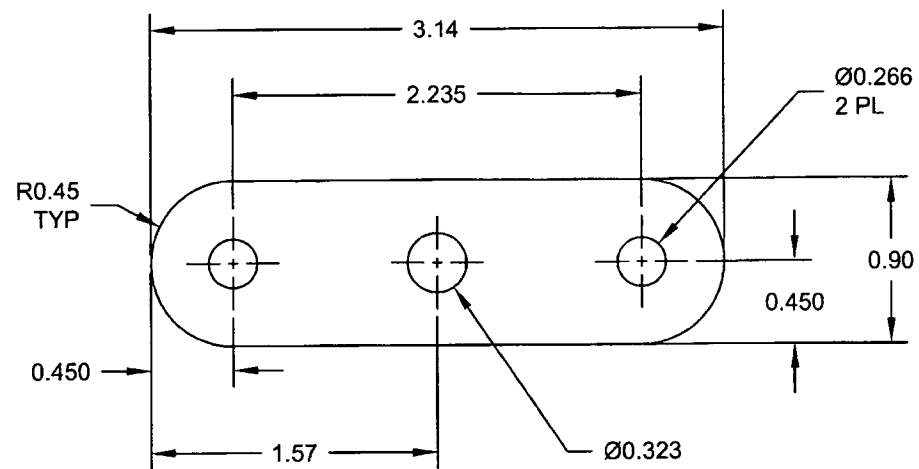
DETAIL D: HOOP & HINGE PLATE DETAIL
FRONT SHOWN, BACK SIMILAR
SCALE 3X



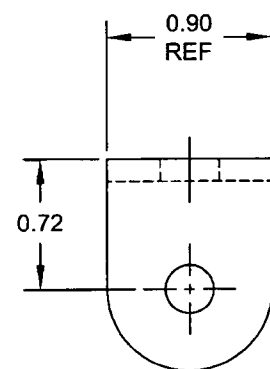
DETAIL C: SPACER INSTALLATION
SCALE 4X

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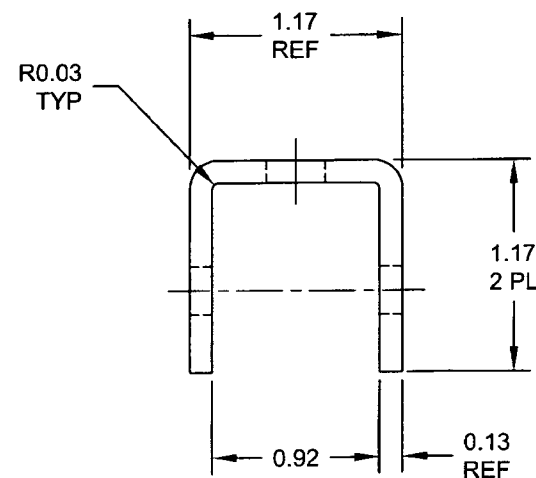
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1 D3516-11F CLEVIS FLAT PATTERN

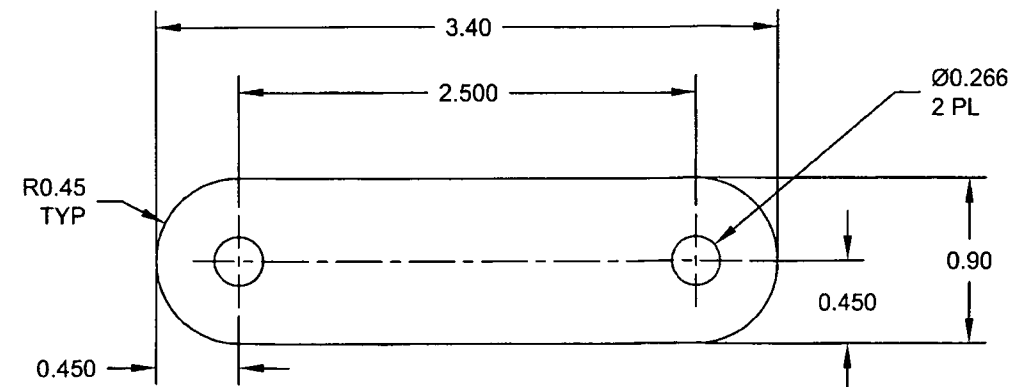


D3516-11 CLEVIS BENDING DETAIL
(MAKE FROM D3516-11F)

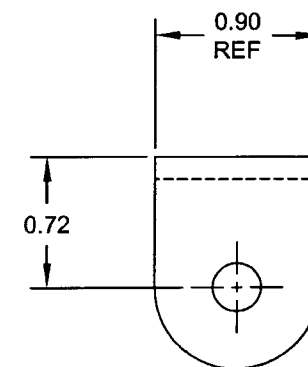


D3516-11/-13 NOTES:

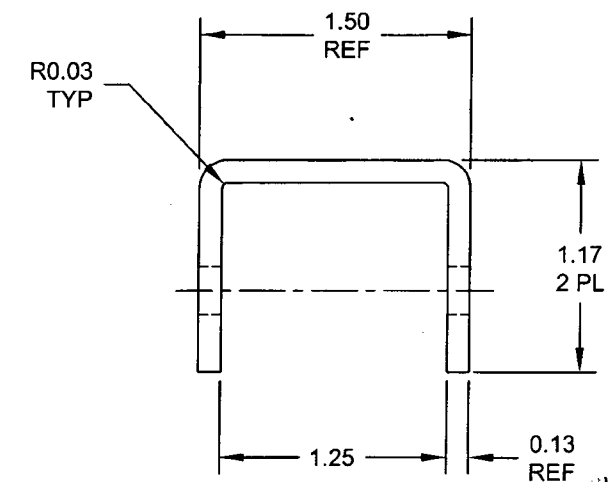
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs
D3516-13 = 0.10 lbs



1 D3516-13F CLEVIS FLAT PATTERN



D3516-13 CLEVIS BENDING DETAIL
(MAKE FROM D3516-13F)



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MFG. APPR.	<i>MD</i>	D3516	SHEET 4 OF 4
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	BASKET BASE ASSEMBLY (A119)	NTS
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